

Date: Friday, 03/04/2009 1:10:14 PM  
 User: Julie Dawson

## Process Sheet

|  |   |
|--|---|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : TURNING DETAIL FOR D2893-1 |
| Job Number : 46924                             |   |
| Estimate Number : 13234                        |   |
| P.O. Number :                                  | Part Number : DSK078                      |
| This Issue : 03/04/2009 S.O. No. :             | Drawing Number : DSK078 REV.A             |
| Prsht Rev. : NC                                | Project Number : N/A                      |
| First Issue : / / Type : MACHINED PARTS        | Drawing Revision : A                      |
| Previous Run : 43870                           | Material :                                |
| Written By :                                   | Due Date : 10/04/2009 Qty: 10 Um: Each    |
| Checked & Approved By : <u>JUD 09-04-03</u>    |   |
| Comment : est rev A. 08.03.13 new issue EC     |   |

## Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

|     |          |                    |
|-----|----------|--------------------|
| 1.0 | D6104005 | Round Billet, 17-4 |
|-----|----------|--------------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)  
 Support

*B 45037* *09/04/04*

|     |            |                            |
|-----|------------|----------------------------|
| 2.0 | MORI SEIKI | MORI SEIKI CNC LATHE LARGE |
|-----|------------|----------------------------|



Comment: MORI SEIKI CNC LATHE LARGE  
 Turn blank as per Folio FA081

*09/04/04*

|     |     |  |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*09/04/04*

|     |     |              |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

*09/04/05 (10)*

|     |             |                       |
|-----|-------------|-----------------------|
| 5.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1  
 Identify and Stock in Kanban  
 Location: *BNC*

*09/04/05 (10)*  
*MF 09-04-06*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

Date: Friday, 03/04/2009 1:10:14 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TURNING DETAIL FOR D2893-1

Job Number: 46924

Part Number: DSK078

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/04/06 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*See previous  
page for  
Job Completion  
Signature.*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

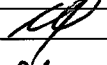

**NOTE:** Date & initial all entries



|  |  |                            |
|--|--|----------------------------|
| <b>DART AEROSPACE LTD</b>                      |  | <b>Work Order:</b> 46924   |
| <b>Description:</b> Turning Detail for D2893-1 |  | <b>Part Number:</b> DSK078 |
| <b>Inspection Dwg:</b> DSK078 <b>Rev:</b> A    |  | <b>Page 1 of 1</b>         |

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article      ☐ Prototype

|               |       |       |                | Record Actual Dimensions |       |       |       |       |
|---------------|-------|-------|----------------|--------------------------|-------|-------|-------|-------|
| Dim           | Min   | Max   | Go/No Go Gauge | 1                        | 2     | 3     | 4     | 5     |
| Lathe Section |       |       |                |                          |       |       |       |       |
| A             | 2.707 | 2.712 |                | 2.710                    | 2.710 | 2.710 | 2.710 | 2.710 |
| B             | 4.946 | 4.966 |                | 4.956                    | 4.956 | 4.956 | 4.956 | 4.956 |
| C             | 3.064 | 3.084 |                | 3.074                    | 3.074 | 3.074 | 3.074 | 3.074 |
| D             | 0.718 | 0.738 |                | .728                     | .728  | .728  | .728  | .728  |
| E             | 0.090 | 0.110 |                | .100                     | .100  | .100  | .100  | .100  |
| F             | 2.934 | 2.954 |                | 2.944                    | 2.944 | 2.944 | 2.944 | 2.944 |
| G             | 2.166 | 2.186 |                | 2.176                    | 2.176 | 2.176 | 2.176 | 2.176 |
| H             | 3.890 | 3.910 |                | 3.900                    | 3.900 | 3.900 | 3.900 | 3.900 |
| I             | 0.914 | 0.934 |                | .924                     | .924  | .924  | .924  | .924  |
| J             | 0.022 | 0.042 |                | .032                     | .032  | .032  | .032  | .032  |
| K             | 0.109 | 0.129 |                | .119                     | .119  | .119  | .119  | .119  |
| L             |       |       |                |                          |       |       |       |       |
| M             |       |       |                |                          |       |       |       |       |
| N             |       |       |                |                          |       |       |       |       |
| O             |       |       |                |                          |       |       |       |       |
| P             |       |       |                |                          |       |       |       |       |

|   |                       |
|---|-----------------------|
| <b>Measured by:</b>  | <b>Date:</b> 09/04/04 |
| <b>Audited by:</b>   | <b>Date:</b> 09/04/05 |
| <b>Prototype Approval:</b>  | <b>Date:</b>          |

| Rev | Date     | Change    | Revised by   | Approved  |
|-----|----------|-----------|--|---|
| A   | 08.04.22 | New Issue | KJ/JLM  |  |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
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|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

|  |               |                            |
|--|---------------|----------------------------|
| <b>DART AEROSPACE LTD</b>                      |               | <b>Work Order:</b> 46924   |
| <b>Description:</b> Turning Detail for D2893-1 |               | <b>Part Number:</b> DSK078 |
| <b>Inspection Dwg:</b> DSK078                  | <b>Rev:</b> A | <b>Page 1 of 1</b>         |

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

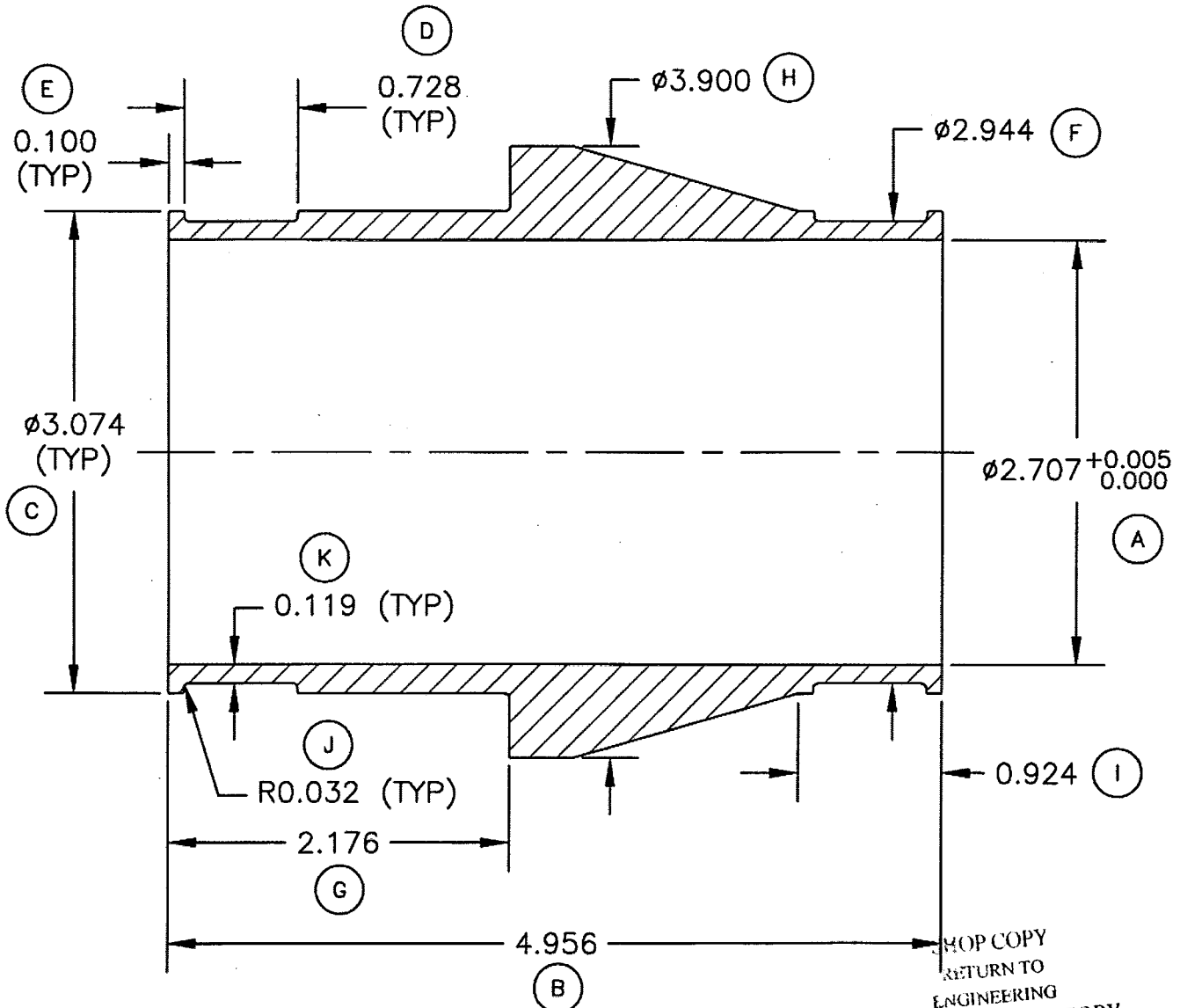
|               |       |       |                | Record Actual Dimensions |       |       |       |       |
|---------------|-------|-------|----------------|--------------------------|-------|-------|-------|-------|
| Dim           | Min   | Max   | Go/No Go Gauge | 1                        | 2     | 3     | 4     | 5     |
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| B             | 4.946 | 4.966 |                | 4.956                    | 4.956 | 4.956 | 4.956 | 4.956 |
| C             | 3.064 | 3.084 |                | 3.074                    | 3.074 | 3.074 | 3.074 | 3.074 |
| D             | 0.718 | 0.738 |                | .728                     | .728  | .728  | .728  | .728  |
| E             | 0.090 | 0.110 |                | .100                     | .100  | .100  | .100  | .100  |
| F             | 2.934 | 2.954 |                | 2.944                    | 2.944 | 2.944 | 2.944 | 2.944 |
| G             | 2.166 | 2.186 |                | 2.176                    | 2.176 | 2.176 | 2.176 | 2.176 |
| H             | 3.890 | 3.910 |                | 3.900                    | 3.900 | 3.900 | 3.900 | 3.900 |
| I             | 0.914 | 0.934 |                | .924                     | .924  | .924  | .924  | .924  |
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| K             | 0.109 | 0.129 |                | .119                     | .119  | .119  | .119  | .119  |
| L             |       |       |                |                          |       |       |       |       |
| M             |       |       |                |                          |       |       |       |       |
| N             |       |       |                |                          |       |       |       |       |
| O             |       |       |                |                          |       |       |       |       |
| P             |       |       |                |                          |       |       |       |       |

|  |                       |
|--|-----------------------|
| <b>Measured by:</b> <i>[Signature]</i> | <b>Date:</b> 09/04/04 |
| <b>Audited by:</b> <i>[Signature]</i>  | <b>Date:</b> 09/04/05 |
| <b>Prototype Approval:</b>             | <b>Date:</b>          |

| Rev | Date     | Change    | Revised by                | Approved           |
|-----|----------|-----------|---------------------------|--------------------|
| A   | 08.04.22 | New Issue | KJ/JLM <i>[Signature]</i> | <i>[Signature]</i> |

**DART**

|                  |                |   |                        |
|------------------|----------------|---|------------------------|
| DESIGN<br>RT     | DRAWN BY<br>RT | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br>H     | APPROVED<br>H  | DRAWING NO.<br>DSK 078                            | REV. A<br>SHEET 1 OF 1 |
| DATE<br>03.05.20 |                | TITLE<br>TURNING DETAIL FOR D2893-1               | SCALE<br>1:1           |
| A                | 03.05.20       | NEW ISSUE   |                        |

RELEASED  
03.07.01D2893-1 TURNING DETAIL

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